

bal_2_1 - Delta ISPSOft

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Alarm

Local Symbols					
Class	Identi...	Address	Type...	Initial...	Identifier Co...
VAR	b22_m	M35	BOOL	N/A	
VAR	b23_m	M57	BOOL	N/A	
VAR	b24_m	M58	BOOL	N/A	
VAR	b25_m	M59	BOOL	N/A	

```

0001 (* alarmy prenos*)
0002 ldi 24ok
0003 bset d200 0
0004 inv
0005 brst d200 0
0006
0007 ld= d310 0
0008 bset d200 1
0009 inv
0010 brst d200 1
0011
0012 ld= d310 1
0013 bset d200 2
0014 inv
0015 brst d200 2
0016
0017 ld= d310 2
0018 bset d200 3
0019 inv
0020 brst d200 3
0021
0022 ld= d310 3
0023 bset d200 4
0024 inv
0025 brst d200 4
0026
0027 ld= d310 4
0028 brst d200 5

```

Main

Local Symbols					
Class	Identi...	Address	Type...	Initial...	Identifier Co...
VAR	cas	T0	TIMER	N/A	
VAR	cas_1	T15	TIMER	N/A	
VAR	cas_2	T17	TIMER	N/A	
VAR	cas_3	T16	TIMER	N/A	

```

0145 RST M1320 (*ascii mode*)
0146
0147
0148 ldi 24ok
0149 out reset
0150 rst servo_on
0151
0152 (*stop cyclu*)
0153 ldi stop_auto
0154 or stop_disp
0155 or je_alarm
0156 set stopM
0157 ld startM
0158 or start_disp
0159 rst stopM
0160 (* zapnuti vysavace a vacuove pum)
0161 ld startM
0162 or start_disp
0163 ani je_alarm
0164 set vac_pump
0165 set vysavac
0166
0167 ld stopM
0168 and m44
0169 ori 24ok
0170 rst vac_pump
0171 rst vysavac

```

Sequence

Local Symbols					
Class	Identi...	Address	Type...	Initial...	Identifier Co...
VAR	strih	N/A [Au	pricny_	N/A	
VAR	step_9b	M10	BOOL	N/A	
VAR	step_9a	M65	BOOL	N/A	
VAR	step_9	M9	BOOL	N/A	

```

0115 rst step_3
0116
0117 (* vynulovani registru polohy*)
0118 ldp step_5
0119 set M1122
0120 ld step_5
0121 MODRW 10 16 16#0520 D106 32
0122 ld step_5
0123 rst step_4
0124
0125 (* stop a start cyclu*)
0126 ldp step_14
0127 orp m_run
0128 ani stopM
0129 and heat_nok
0130 set step_7
0131 rst step_14
0132 rst step_18
0133 rst step_5
0134 rst m_run
0135 rst step_1
0136
0137 (* step7 zavření nástoju*)
0138 ld step_7
0139 set move_tools_a
0140 set move_tools_b
0141

```

Project

Insert Row:1 Column:1 1426/15872 Steps Offline Driver1, [RS232: COM28] SA2

CS 15:56 27.8.2014